Monday, 7/9/2007 11:46:57 AM Date: Kim Johnston User: **Process Sheet** : CABIN FLOOR PROTECTOR : CU-DAR001 Dart Helicopters Services **Drawing Name** Customer Job Number : 33357 : 12661 **Estimate Number** :NA : D35742 P.O. Number **Part Number** : 7/9/2007 S.O. No. :NA **Drawing Number** D3574 REV.A This Issue : N/A : NC Project Number Prsht Rev. : NA : SMALL /MED FAB : A **Drawing Revision** First Issue Type 30476 : NA Material Previous Run Each : 7/13/2007 **Due Date** Written By Checked & Approved By EC New Issue 07-01-22 Comment Additional Product Job Number: Description: Seq. #: Machine Or Operation: 1.0 F60029 lexan grey Comment: Qty.: 48.0000 sf(s) 16.0000 sf(s)/Unit Total: F60029 lexan sheet Batch: M 103106 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3574 Dwg Rev: ____ Prog Rev:__ 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 B 07-07-17 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK SMALL & MEDIUM FAB RESOURCE 1 5.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary.

Dart Aerospace Ltd

W/O:			WORK ORDER CHANGES					
DATE	STEP	PROCEDURE (CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					· · · · · · · · · · · · · · · · · · ·			
Part No):	PAR #: Fault C	ategory:	NCR: Yes	No DQ	A: <u>4</u>	Date: _	07/07/13
					N/C Close			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section E	3	Verification Section C	Approval Chief Eng			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			Approval QC Inspecto		
<u> </u>										

NOTE: Date & initial all entries

Daţe: Monday, 7/9/2007 11:46:57 AM User: Kim Johnston **Process Sheet** Drawing Name: CABIN FLOOR PROTECTOR Customer: CU-DAR001 Dart Helicopters Services Job Number: 33357 Part Number: D35742 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 PACKAGING 1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion a of of 13

Dart Aerospace Ltd

W/O:		WORK ORDER CH	IANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	

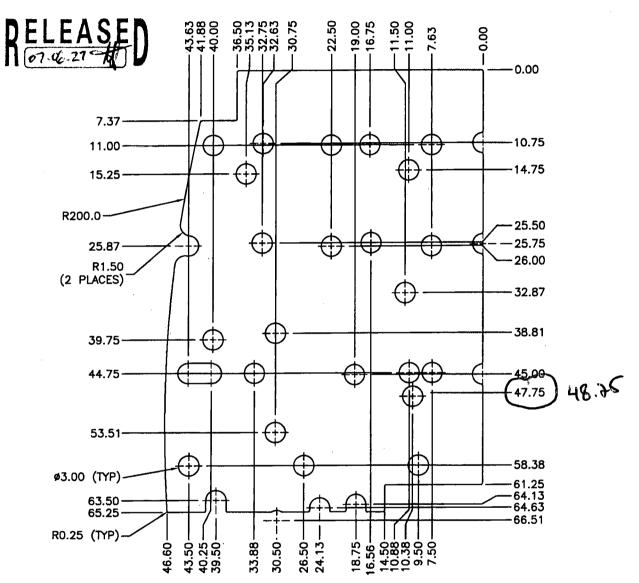
QA: N/C Closed: ____ Date: ____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE STEP		Description of NC		Corrective Action Section B		Verification				
		Section A	Initial Chief Eng	Action Description Sign & Date		- Verification Approval Section C Chief Eng		Approval QC Inspector		
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NOTE: Date & initial all entries



DESIG		CB	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHEC	KED	APPROVED #	DRAWING NO.	REV. A
1		#	D3574	SHEET 1 OF 5
DATE			TITLE	SCALE
07.0	06.08		CABIN FLOOR PROTECTOR	1:14
A		07.06.08	NEW ISSUE	



D3574-1 CABIN FLOOR PROTECTOR (SHOWN), D3574-2 (OPPOSITE)

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THREE, COPY RETURN TO TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) ENGINEERING
- 2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

LUNCONTROLLED COPY

4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INSTENDMENT ON SMOOTH SIDE OF PART ON SMOOTH SIDE OF PART

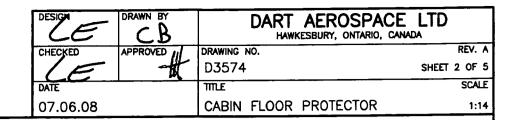
WITHOUT NOTICE WORK ORDER

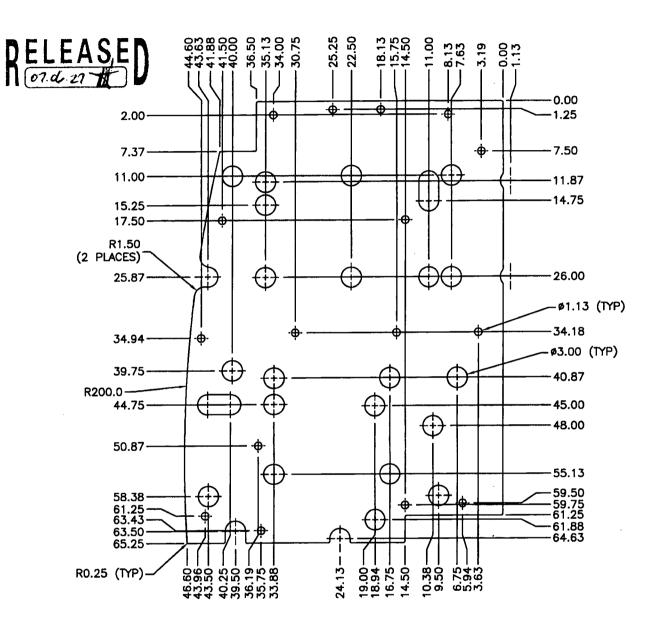
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

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D3574-3 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 STHICK) PY TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) RETURN TO ENGINEERING
- 2) FINISH: NONE

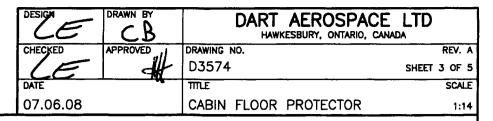
WORK ORDER

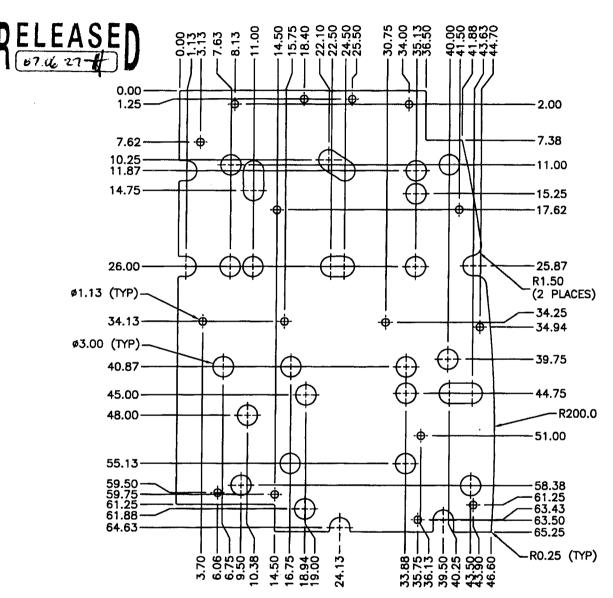
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

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D3574-4 CABIN FLOOR PROTECTOR

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MIEXS 125-F60029-04) TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) RETURN TO
- 2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ENGINEERING

4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INKCOMARKER ED COPY
ON SMOOTH SIDE OF BART SUBJECT TO AMENDMENT ON SMOOTH SIDE OF PART

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

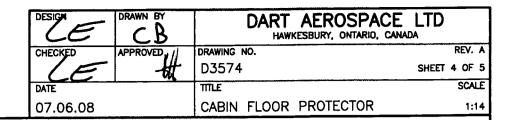
7) CHECK PER TEMPLATE DT8963

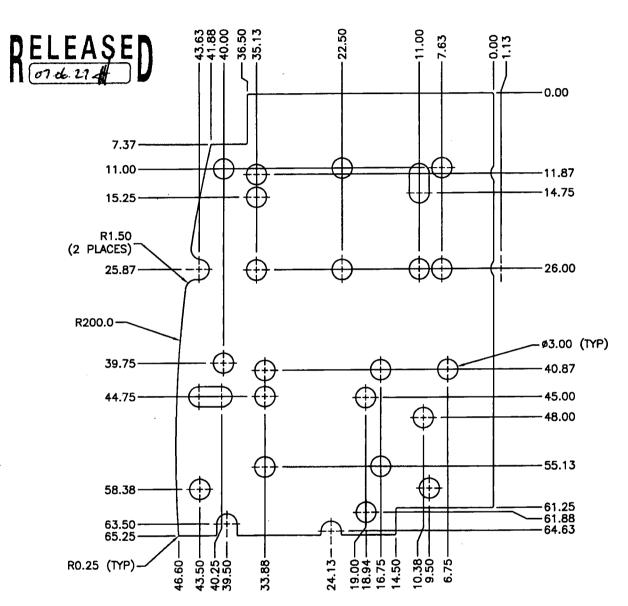
WITHOUT NOTICE WORK ORDER

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D3574-5 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THIS BY TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) RETURN TO
- 2) FINISH: NONE

ENGINEERING

- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT NOR WARKER DIED COPY
 ON SMOOTH SIDE OF PART

 5) ALL DIMENSIONS ARE IN INCHES LINESS OTHERWISE NOTED

 ENGINEERING
 NOTED COPY

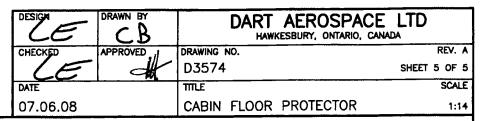
 SUBJECT TO ASSOCIATE
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

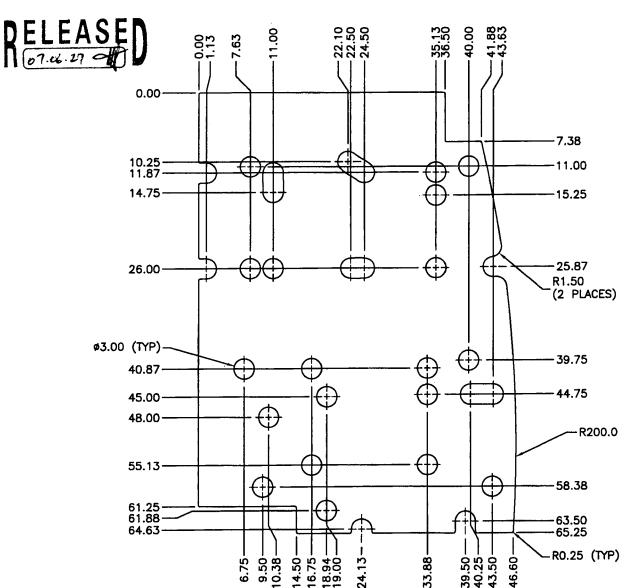
WORK ORDER NO. 3336

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D3574-6 CABIN FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICKY TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04) SHOP CUPY RETURN TO
- 2) FINISH: NONE

ENGINEERING

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT NEW THARKER ON SMOOTH SIDE OF PART SUBJECT TO AMENDMENT
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

WITHOUT NOTICE WORKORDER

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DART AEROSPACE LTD	Work Order:	33357
Description: CABIN FLOOR PROTECTOR	Part Number:	03574-2
Inspection Dwg: Rev: A		Page 1 of 1

•	X	First Artic	le	Proto	type	•
Tole	erance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4/	030	7.37	_* <u>_</u>			
		1(.00	*			
+/-	. 636	15.72	*			
+/_	. 030	78.81	¥			
4/-	. 030	39.75	*			
4/-	. 030	44.75	*			
+/_	. 030		¥			
+/*	N SON		X			
	.030	63,50	¥	<u> </u>		
+/_	o 3 0	65.25	×			
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	+/- +/- +/- +/- +/- +/- +/-	+/030 +/636 +/030 +/030 +/030 +/030 +/030 +/030	Tolerance Dimension +/030 7.37 +/030 1(.00 +/036 15.25 +/030 39.75 +/030 44.75 +/030 53.51 +/030 63.50 +/030 65.35	Tolerance Dimension Accept #	Tolerance Actual Dimension Accept Reject +/030 7.37 ** +/030 1(.00	Tolerance Dimension Accept Reject Method of Inspection +/030

Measured by: 16	Audited by:	5.0	Prototype Approval:	
Date: 07-07-12	Date:	0/1/12	Date:	

ſ	Day	Data	Change	Revised by	Approved
1	Rev	Date		KJ/RF	İ
j	Α		New Issue		

DART AEROSPACE LTD	Work Order:	33357
Description: CABIN FLOOR PROTECTOR	Part Number:	D 3574-2
Inspection Dwg: Rev: A	·	Page 1 of 1

First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.75	4- ,030	10.75	*			
14.75	4/030	4.75	_\ k			
25.50	4/030	25,50	¥			
25.75	4030	25.75	*)	
26.00	4/- 030	76.00	*			
33.87	4/ 036	35.87	*			
38.81	4/ 030	18.82	*			
45.00	4/030	45.00	*			
48.25	4/030	48.25 \$				
\$8.38	4/030	\$8.38	*			
76.13	4/020	61.25	*			
64-13	4/030	64.13	*			
64.63	+/030	64.63	X			•
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Measured by: 1,D	Audited by:	Prototype Approval:	
Date: 07-07-17	Date: Alala	Date:	

Day	Data	Change	Revised by	Approved
Rev	Date		KJ/RF	
Α		New issue	NOTE	<u></u>

DART AEROSPACE LTD	Work Order:	33357
Description: CABIN FLOOR PROTECTOR	Part Number:	D 3574-2
Inspection Dwg: Rev: A		Page 1 of 1

	X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
46.60	4- ,030	46.60	*			
43.50	4/030	43.50	*			
40.25	4030	40.75	*			
39.50	4/030	34.50	*			
33.88	t/030	33.88	*			
30.50	4/030	30.50	*			
26.50	4/030	26.50	*			
24.13	4/030	24,13	*			
18.75	+/030	(8.75	14	<u> </u>		
16.56	4/030	16.56	*			
14.50	4030	14,50	*	ļ		
10-88	1/- 030	10.88	*			
(0.38	1/030	10.38	*			•
9.50	+/- ,030	9,50	*		1	
7.50	4/- ,030	7,50	*			
				-		

Measured by: R	Audited by:	Prototype Approval:	
Date: 67-67-12	Date: 07/07/12	Date:	

Rev	Date	Change	Revised by	Approved
A	Date	New Issue	KJ/RF	

DART AEROSPACE LTD	Work Order:	_333<7
Description: CABIN FLOOR PROTECTOR	Part Number:	D 3574-2
Inspection Dwg: Rev: A		Page 1 of 1

Y First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
43.63	4/- 1030	43.63	*			
41.88	4/030	41.88	*			
40.00	4030	40.00	*			
36.50	1/030	36.50	*			
35.(3	+/030	35.13	*			
39.75	1/030	32.75	*			
37.63	1/030	39.63	*			
30-75	4/030	30.15	*			
27.50	4/030	33.50	*			
00.91	7/030	19.00	¥			
16.75	4/- ,630	1675	*			
11.50	+/030	11,00	*			
((-06	1/030	ال ، هن	<b>*</b>	ļ		•
7.63	+/030	7,63	*	-		

Measured by:	1R	Audited by:	Prototype Approval:	
	0]~0]-(]	Date: UHUF112	Date:	

Dave	Data	Change	Revised by	Approved
Rev	Date		KJ/RF	
i A		New Issue		